

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008595**Date Inspected:** 23-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	CWI: Wang Chuan Qing/Liu Xiaojun			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Tower components		

Summary of Items Observed:

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Dilip Chakrabarti was present during the times noted above for observations relative to the work being performed.

Bay# 10- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld Joint# 82B located on PCMK NSTL3-3 B/K. Welder is identified as 050041. ZPMC QC is identified as Chen Ying Xin. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2231-C-U5-F.

Welding of weld Joint# 156,158 located on PCMK EDF1 A27 B/E. Welder is identified as 052075. ZPMC QC is identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2133.

Welding of weld Joint# 154 located on PCMK EDF1 A27 B/E. Welder is identified as 052075. ZPMC QC is identified as Wang Chuan Qing. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-2132.

SAW Process:

Welding of weld Joint# 1A located on PCMK ED1 A5007-21,22,23,24. Welder is identified as 040460. ZPMC

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QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U3b-S-1.

Welding of weld Joint# 1A located on PCMK ND1 A5012-9,10,11,12. Welder is identified as 250252. ZPMC QC is identified as Wang Hao. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-3221-TC-U3b-S-1.

Bay# 11- Tower Assembly:

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Welding of weld Joint# 1 located on PCMK WSD1 FESA4-4 B/F. Welder is identified as 066882. ZPMC QC is identified as Liu Xiao Zhong. The welding variables recorded by QC appeared to comply with the specified WPS no. B-T-4332-TC-P4-F

Tower Machine shop(Outside):

This QA Inspector randomly observed the following work in progress:

FCAW Process:

Weld buttering on Skin plate, west shaft lift#1 as per Weld Repair Report (WRR)# T-WR-1961 dated 08.16.09. Welder is identified as 068923. ZPMC QC is identified as Zhan Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2(G) 2F Repair.

Weld buttering on Skin plate, west shaft lift#1 as per Weld Repair Report (WRR)# T-WR-1961 dated 08.16.09. Welder is identified as 070254. ZPMC QC is identified as Zhan Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2(G) 2F Repair.

Weld buttering on Skin plate, west shaft lift#1 as per Weld Repair Report (WRR)# T-WR-1961 dated 08.16.09. Welder is identified as 067184. ZPMC QC is identified as Zhan Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-3(G) 3F Repair.

Weld buttering on Skin plate, west shaft lift#1 as per Weld Repair Report (WRR)# T-WR-1961 dated 08.16.09. Welder is identified as 070212. ZPMC QC is identified as Zhan Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-3(G) 3F Repair.

Weld buttering on Skin plate, west shaft lift#1 as per Weld Repair Report (WRR)# T-WR-1961 dated 08.16.09. Welder is identified as 066471. ZPMC QC is identified as Zhan Bo. The welding variables recorded by QC appeared to comply with the specified WPS no. WPS-345-FCAW-2(G) 2F Repair.

Unless otherwise noted, all work observed on this date appeared to be generally comply with applicable contract documents.

Summary of Conversations:

No relevant Conversation

Comments

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This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Chakrabarti,Dilip Kumar	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
